



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4635-142
Job Sheet 167085-E



Part No: D4635-142

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start Up Small Fab	
100	Small Fab	1 pcs		11/9/17	0.00	0.80	Small Fab	D.M.L 17-12-27
110	Small Fab	1 pcs		11/10/17	0.00	0.80	Small Fab	D.M.L 17-12-27
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	D 17-12-27
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.M.L 17-12-27
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-142 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation 5026604	D4635-2 5026258	1	2	0	0
	D4669-1	2	27	0	0
	D4695-042 5026154	1	1	0	0
	D4732-3 5021857	1	4	0	0
	D4732-31 5021856	1	4	0	0
	D4732-35 5021854	1	5	0	0
	D4732-7 5021853	1	2	0	0
	D5022-1 5028243	1	4	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	MRB (QSI042) Approval			
Job No: 167085-E Mfg Date: 12/22/17 Change No: Operation: Revision: PART NO: Packaging D4635-142 Fwd Ceiling Replacement Panel Assembly, RH S026605 DART AEROSPACE		Completed By			
		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			
		Root Cause Environment ☐ No Design ☐ Ope Doc/Data ☐ Offs Equip/Tooling ☐ Supp Handling/Pre ☐ Train Material ☐ Use f Internal Transport ☐ Poor Information Tribal Knowledge ☐ Rushing LOA ☐ Product Improvement Substation ☐ Process Improvement Past Expiry Date ☐ Manufacturing Process Misidentified ☐ Past Due OTHER : _____			s/Surge ☐ ram ☐
Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com